

Date: Thursday, 17/07/2008 1:40:03 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LOWER BLADE SUPPORT ASSY		
Job Number	: 40598						
Estimate Number	: 13472						
P.O. Number	:			Part Number	:	PB674300179	
This Issue	: 17/07/2008	S.O. No.	:	Drawing Number	:	B6743001 P.11	
Prsh Rev.	:	NC		Project Number	:	N/A	
First Issue	:	/ /	Type	Drawing Revision	:	B1	
Previous Run	:			Material	:		
Written By	:			Due Date	:	24/07/2008	Qty: <i>10</i> Um: Each
Checked & Approved By	:	<i>MF 08-07-17</i>					
Comment	:	Est Rev:A 08-07-17 new issue DD verified by:ec					

## Additional Product

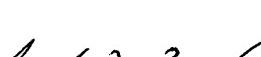
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001171	Mounting Plate	
			<i>08-07-17</i>
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)	
		Mounting Plate	
		batch: <i>331670</i>	
2.0	PB6743001177	Short Support Plate	
			<i>08-07-17</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Short Support Plate	
		batch: <i>340031</i>	
3.0	PB6743001179	Short Sside Plate	
			<i>08-07-17</i>
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		Short Sside Plate	
		batch: <i>340032</i>	
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			<i>08-07-17</i>
		Comment: Weld assembly as per dwg PB67-43001	
5.0	QC9	VISUAL WELDING INSPECTION	
			<i>08-07-17</i>
		Comment: VISUAL WELDING INSPECTION	

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Job Number: 40598		Part Number: PB674300179
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 S 08/07/21 Y6
7.0	POWDER COATING	POWDER COATING  M102316
Comment: POWDER COATING		 6X
<p>1- put screws in nut plates before powder coating to keep thread clean</p> <p>2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3</p>		
START TIME:	<u>1'40</u>	
OVEN TEMPERATURE:	<u>320° F</u>	
FINISH TIME:	<u>2'00</u>	
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 m-f 08/07/21 6
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST511		 L 08/07/23 6
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 08/08/2018
Job Completion		 W 08/08/19

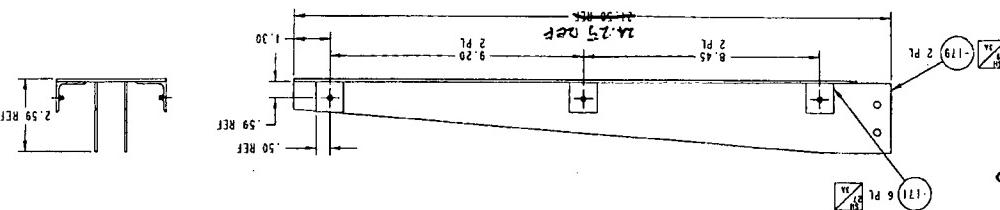
ORIGINAL

PREMIER AVIATION, INC.  
P.O. BOX 43001  
MS202603-A MULGATE (2)

SCALE 0.500

(2)

-79 LOWER BLADE SUPPORT ASSEMBLY



# 40598

SCALE 0.500

(2) -75 UPPER BLADE SUPPORT ASSEMBLY

MS202603-A MULGATE (2)

1.50

1.00

4.00 RLT

6 PL EA

2.59 RLT

D150-1

.50 RLT

2 PL

9.31

1.36

1.50

4.00 RLT

1.00

4 PL

1.36

2 PL

9.31

1.36

2 PL

1.36

DART AEROSPACE LTD	Work Order:	39752
Description: <del>Lower Blade Support Assy</del> (-79 Lower Blade Support Ass.)	Part Number:	367-43001-79
Dwg: 367-43001 SHEET 11	Qty:	10 Page of

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
1 cut	GA	Short support plate -177 use mat: .090 6061 T6 (m7950) cut part 20.25 x 400 mark & drill holes as per dwg. & places center 1/2" in and 1.25" in from one end. deburr Batch: D40031		08-06-26	1
2 cut	GA	Short side plate -179 use mat: .125 6061 T6 (m15120) cut 23.50 x 2.50 mark & drill holes as per dwg. cut angle as per dwg. Batch: D40032		08-06-26	2
3 cut	GA	mounting plate -171 use mat: AND10133-1002 6061 T6 20-A-200/8F alt mat: .090 THK, 6061 T6 QQ-A-250/11 cut 1" x 1" (mark) mark hole center .193 & .098 hole each side for nut plate Batch: B37670		08-06-26	120
4 install	GA	Counter sink holes as per dwg. (a) install nut plate (MS21075L3N)(M16255) using rivet (MS21426A83-4)(M9748) to mounting plate -171 Batch:		08/07/10	6
5A weld	WA	weld parts -177 & -179 & 171 as per drawing use 1" space (square tube) for gap between side plate -179		100-07-17	12
6 clean	ND	cleaned according QSI 0054.1			
7 paint	PP	powder coat green safety as per DART QSI 0054.3			
8 QC3	Inspect Powder Coat.				
9 ST	Underapply & Stock				
5B	05/09	Completed Work / Weld	QC9	PD	08-07-17

Rev	Date	Change	Revised By	Approved

# PRELIMINARY ISSUE